

# Work Order ID 48145

Friday, June 26, 2009 9:17:31 AM



Page 1

Item ID:	D3117-1	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Seal Retainer					
Start Date:	7/15/2009	Start Qty:	500.00		Cust Item ID:	
Required Date:	8/3/2009	Req'd Qty:	500.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3117	Rev C

100		0.00							
	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>8843</u> <input type="checkbox"/> D3117-1 Seal as per Dwg D3117 <input type="checkbox"/> Possible Supplier: VIP Rubber Replace Premier <input type="checkbox"/> P/N: B45-43000-01 <input type="checkbox"/> Material release note required								

*See attached w/o*

110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								

*Pu 9/7/15 500*

120		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control	Check dims to dwg and certification attached.								

*=> 809/09/15 x 500 ft*

**Work Order ID 48145**

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Item ID: D3117-1

Accept

Revision ID: C

Item Name: Seal Retainer

Start Date: 7/15/2009 Start Qty: 500.00

Required Date: 8/3/2009 Req'd Qty: 500.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location 406

0.00



Packaging

Memo

0.00

Packaging

9/7/16 500 fb sp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/2009 [Signature]W 91.07.17

# Picklist Print

Page 1

Friday, June 26, 2009 9:17:31 AM

Work Order ID: 48145



Parent Item: D3117-1RevC



Parent Item Name: Seal Retainer



Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 500.00

Required Qty: 500.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3117-1PRevC  Seal Retainer		Purchased	No			110	Each	0.0000	500.0000 			

Date: Friday, 22/05/2009 2:26:34 PM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SEAL
<b>Job Number</b> : 48145	
<b>Estimate Number</b> : 10558	
<b>P.O. Number</b> :	<b>Part Number</b> : D31171
<b>This Issue</b> : 22/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3117 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 47474	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 17/06/2009 <b>Qty:</b> 500 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>C209/05/22</u>	
<b>Comment</b> : Est. A 02.05.15 New Issue NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 8843

D3117-1 Seal as per Dwg D3117

Possible Supplier: VIP RubberReplace Premier

P/N: B45-43000-01

Material release note required

C209/05/22  
500

2.0	D31171P	Seal Retainer
-----	---------	---------------

**Comment:** Qty.: 1.0000 f(s)/Unit Total : 500.0000 f(s)

SEAL

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect Level 6 Check dims to dwg and certification attached.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 22/05/2009 2:26:34 PM  
User: Chantal Lavoie

## Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** SEAL

**Job Number:** 48145

**Part Number:** D31171

Job Number:



**Seq. #:**

**Machine Or Operation:**

**Description :**

6.0

QC21

FINAL INSPECTION/W/O RELEASE



**Comment:** FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

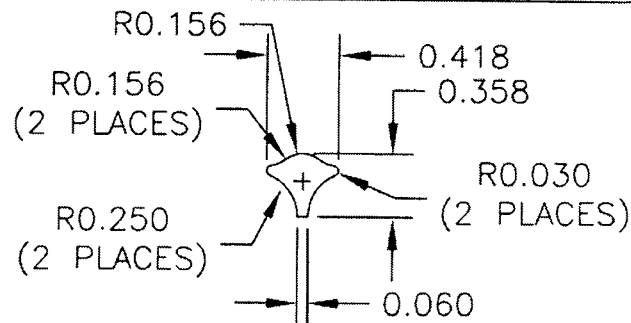
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

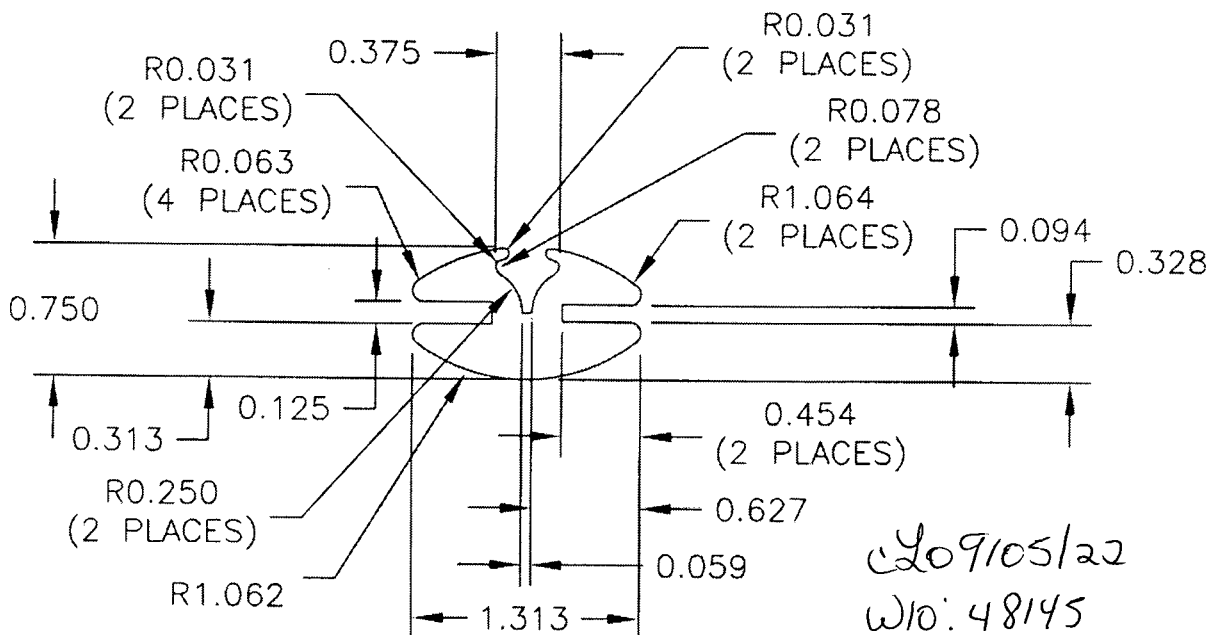
DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3117	REV. C SHEET 1 OF 1
DATE 05.10.03		TITLE SEAL	SCALE 1:1
A	02.04.15	NEW ISSUE	
B	04.10.18	UPDATES NOTES	
C	05.10.03	50 DUROMETER WAS 60 DUROMETER	



RELEASED  
05.10.03 *[Signature]*

**D3117-3-XXXX SEAL FILLER**

REPLACES PREMIER P/N B45-43000-03



209/05/22  
W10: 48145

**D3117-1-XXXX SEAL RETAINER**

REPLACES PREMIER P/N B45-43000-01

**NOTES**

- 1) -XXXX = LENGTH IN INCHES (EG. 10" LONG = -0100, 87.5" LONG = -0875)
- 2) MATERIAL: BLACK RUBBER 50 DUROMETER (HARDNESS) NEOPRENE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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# Vip Rubber Company

EXTRUDED AND MOLDED RUBBER • EXTRUDED PLASTIC

540 S. CYPRESS STREET, LA HABRA, CA 90631

(310) 905-3456 • (800) 722-4VIP

Fax: (310) 905-3460

*310  
order*

*3626*

## CERTIFICATION OF COMPLIANCE

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY ONTARIO, CANADA  
K6A1K7 613-632-9577

ITEM NO.

RE-7107-189"-0156

CUSTOMER PO.

P000008843

DATE

6-11-09

SHIPPER NO.

*80646*

*#1299*

### PART NO./DESCRIPTION

P/N D3117-1 REV C RETAINER

P/N D3117-3 REV C FILLER

(DWG. #D3117 REV C)

QUANTITY  
ORDERED

500 FT

500 FT

CURE DATE

*3-0-09*

SPECIFICATION

50/NEOPRENE FORMULATED TO MEET THE FLAME  
RESISTANCE TEST OF FAR 25.853a LOT # *93559*

By

*Martin Perez*

MARTIN PEREZ  
TECHNICAL DIRECTOR

VIP RUBBER COMPANY

*8*  
*09/04/15*

DATE SHIPPED

*7/9/09*

QTY. SHIPPED

*500 FT*

*500 FT*



**VIP Rubber Company, Inc.**  
540 S. Cypress  
La Habra, Ca. 90631

# **FINAL INSPECTION REPORT**

<b>Customer</b> Dart Aerospace Ltd.				<b>Purchase Order #</b> P000008843			
<b>Part Number/Dwg. Number</b> D3117-1 &-3 (Filler & Retainer)				<b>Revision</b> C			
<b>Job #</b> 1299		<b>Lot #</b> 193141		<b>Material</b> Rubber 4.0 / C=0; Plastic 6.5 / C=0			
<b>Lot Size</b> 500 FT		<b>Sample Size</b> 500 FT					
<b>Dimensions Measured</b>							
<b>Dim.</b>	<b>.418</b>	<b>.750</b>					
<b>Tol. +/-</b>	<b>.051</b>	<b>.063</b>					
<b>Range</b>	0.469	0.813					
	0.367	0.687					
<b>Descr.</b>	<b>Filler</b>	<b>Retainer</b>					
1	.418	.800					
2	.418	.800					
3	.420	.800					
4	.420	.805					
5	.418	.800					
6	.418	.800					
7	.420	.805					
8	.420	.800					
9	.418	.800					
10							
11							
12							
13							
14							
15							
16							
17							
18							
19							
20							
<b>Other Observations (If Required)</b>							
	<b>Required</b>	<b>Tolerance</b>	<b>Actual</b>		<b>Required</b>	<b>Tolerance</b>	<b>Actual</b>
<b>Durometer</b> 50		+/- 5	50		<b>Visual</b>	✓	N/A Ace
<b>Color</b> Black		N/A	Ace		<b>Marking</b>	N/A	N/A
<b>Inspection Notes:</b>							
<b>No. of Observations</b> 12		<b>Qty. Approved</b> 12		<b>Qty. Rejected</b> 0			
<b>Inspected By</b> J.O.				<b>Date</b> 7/9/09			